|--|

Work Order II				*103	3928*		Ac	M			Page 1
Item ID: D39. Revision ID: Item Name: Seath	20-7 elt Guide	e Shim		Accept	*N900)040	1100) *	Setup Star Stop	1.7	S1* S2*
Start Date: 7/4/2 Required Date: 7/18/ Reference:	013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:					· N	157"
Approvals: Pro	cess Pla	ın: MF.	Date: 3-7- L	Tooling:	D	ate:	_	F	Run Star	* *N	R _. 1*
QC			Date:	SPC (Y/N):		ate:			Stop	o	R2*
Sequence ID/ Work Center ID		Operation Description	İ	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Rev	ision Nbr									
D3920	В		**								₹. -
100		FLOW WATER JET		0.00				6	6		Juis-07-0
Waterjet FLOW CNC Waterjet COCOL , 263		Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_ 2-Deburr if	<u>B</u>	0.00		, ed.					<u> 7807-0</u> 1-0
110		QC2- Inspect parts off n	·	0.00							
QC Quality Control		Memo		0.00				<u></u> 6	0		JM13-07-08
120		QC8- Inspect parts - sec	ond check	0.00							
120 QC Quality Control		Memo		0.00				0	B-07.	೦೪_	- .09 -

DQA:	 	Date:			_							•	A DT
					WORK ORDER NON	-C(ONFO	RMANCE / UPD	DATE				DARI
QA Closed:		Date:							We	ork Order up	date only		A2.00
Work Order	·:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part No					Rework Scrap Use-as-is Suspected Unapproved			Machining noforming	Crosstube Small Fab Finishing Composite	1	Water Je d. Eng. Coor e/Packagin Supplie	g	Engineering Quality Other
Root				Desc	ription of work order update		I Initial	Action	n	Sign &			
Cause	Date	Step	Qty		or non-conformance		ief Eng	į.		Date	Verificati	on	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved								·					
						FAI	ULT CAT	TEGORY					
Landing	g Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	FAULT CATEGORY Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge						Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
_ ,	Wave/Tw	-	e	-	Fit/Function	-	ł	Lalibration Sequence					

Work Orde				Page 2									
Item ID: Revision ID: Item Name:	D3920-7 Seatbelt Guid	de Shim		Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*	-
Start Date: Required Date: Reference:	7/4/2013 7/18/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:					IV		
Approvals:	Process Plan: QC:					ate:				Start Stop		R1* R2*	
Sequence ID/ Work Center II 130 *130* Brake NC	0	Operation Description Form as per dwg NC BRAKE Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	- 31-712 0
*140 *140* QC Quality Control		QC5- Inspect part compl	·	0.00	33			S	- <u>,</u>				>
150 *150* Packaging Packaging		Identify as per dwg & Sto	ock Location.	137) w 9002 0.00				_5×	-	-		\$ 2	13

DQA:		WIL	Date:	13/	08/1							•	AA PT
	À	HI.		121	na1.	WORK ORDER NON	-CC	ONFO	RMANCE / UI				AEROSPACE
QA Closed:	4	HX.	Date:	12/10		Я				W	ork Order up	date only	
Work Orde	er: T	D2	03 92	28 7		DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
		D39 13-				Rework Scrap Use-as-is Suspected Unapproved		ŀ	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descr	ription of work order update	ı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material		,			Wa	of to leave		AS. 16	Scapa	dituy	SB 13/57/58	AS 16 9-19	16 8-89
Operator Offset/Setup	25	13/07/08	130	/		it	01 212 1				13/0/24	13/07/24	
Process Supplier					BC.	Testing tooling has	tooling has Blotter 24.50.						Q52042
Training					NUX	Veen couter who						A -	de n
Transport Unapproved					102	Testing tooling has been cutas yet this Port					7	ANDARD	DE Toles
							FAI	ULT CAT	TEGORY			18	10 10 10
Landi	ng G	ear				General		_					Kegaling
		Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced
		Centre No	t Concen	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Щ	Cracks Broken/Damage/Defe						Hardware Part Incorrect					Temperature/Cure
	-	Crimp/Kin	k/Ripple,	/Wave		Burrs	Inspection Incomplete/Unqualified Part Lost/Missing					ssing	Weld
	-	Cuffs			<u> </u>	Contamination	Instructions Incomplete/Unclear Part Moved					Wrong Stock Pulled	
	$\overline{}$	Crushing				Countersink	Misaligned/off center Positioned Wrong					,	
	-	Heat Treat			<u> </u>	Cut Too Short		Mislabe			Power Loss/	-,	Other
	-	nspection	•	Tube		Drawing	<u></u>	Misread	d		QC. no to	Day FOR P	ant.
	-	Marks/Ch			<u> </u>	Drill Holes		Off-set					
	-	Turning Se	•			Finish		1	Calibration			<u> </u>	
1 1	. 1	Wave/Twi	ist in Tub	P	1	Fit/Function	1	IOut of 9	Seguence				

Work Ord Thursday, July		-				Page 3						
Item ID: Revision ID: Item Name:	D3920-7 Seatbelt Guid	te Shim		Accept	*N900	040	100)*	Setup	Start Stop	1/1	S1*
Start Date: Required Date: Reference:	7/4/2013	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item 1 Customer:	ID:				эсор	^N	S2*
Approvals:	00	an:	Date:			ate:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center ID		Operation Description	. , , , , , , , , , , , , , , , , , , ,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*160 *160* _{QC}		QC21- Final Inspection -	Work Order Release	0.00						13	7/6	24

Quality Control

W 13-072+3

DQA:			Date:													
			_			WORK ORDER NON-	-CC	ONFO	RMANCE / L			' <u>-</u> -	AEROSPACE			
QA Closed:			Date:							\	Vork Order up	date only				
Work Orde	er:					DISPOSITION		:		AGAINST D	EPARTMENT	/PROCESS				
	-				_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering			
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
	_					Use-as-is			noforming	Finishing		re/Packaging	Other			
NCR N	No		<u>-</u>			Suspected Unapproved		·	Large Fab	Composite		Supplier				
Root			-		Descr	ription of work order update		nitial	Ad	ction	Sign &	i				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector			
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Doc/Data																
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	-	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced			
		Centre No	ot Concer	ntric	<u> </u>	BOM/Route		Grain			Over/Under	tolerance	Set-up			
	${f H}$	Cracks				Broken/Damage/Defect	_	Hardwa	re		Part Incorre	ct _	Temperature/Cure			
	_	Crimp/Kir	nk/Ripple	/Wave		Burrs	<u> </u>	Inspecti	on Incomplete/l	Jnqualified	Part Lost/Mi		Weld			
	Ш	Cuffs				Contamination	L	t	ions Incomplete,) -	Part Moved		Wrong Stock Pulled			
	Crushing					Countersink	L	_	ned/off center	· . [Positioned V	Vrong	<u>!</u>			
	Heat Treat					Cut Too Short	Mislabeled Power Loss/Surge					Surge	Other			
•	Inspection Strip in Tube					Drawing		Misread	Í				i			
	Marks/Chatter					Drill Holes	<u></u>	Off-set					!			
	Turning Sequence					Finish	Out of Calibration					!				
: 6	Wave/Twist in Tube					Fit/Function		Out of S								

Picklist Print

Thursday, July 04, 2013 11:39:54 AM

Work Order ID:

103928

Parent Item:

D3920-7

Parent Item Name:

Seatbelt Guide Shim

Start Date: 7/4/2013

Required Date: 7/18/2013

Page 1

Start Qty: 6.00

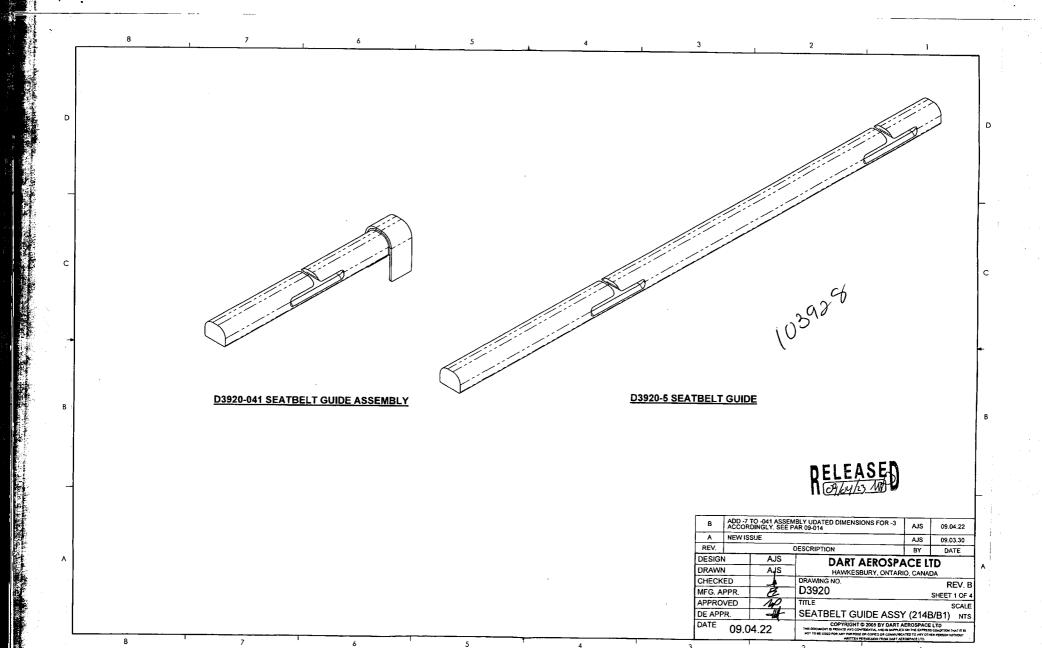
Required Qty: 6.00

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V (O)	nments:	

IPP REV:A 13.07.04 AS PER DWG REV.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	498.1138	0.0158	0 .099789 5	0.1		Jm130706
. .	-			Location		Loc Oty	Lo	c Code					- · ·
A TOTAL CONTRACTOR				MAT021		498.1138			_				
				123	3135	120.2625							
				124	1003	79.19							
				125	5431	10.6613			125	5431			
	•			MI	26075	288			1	 _			

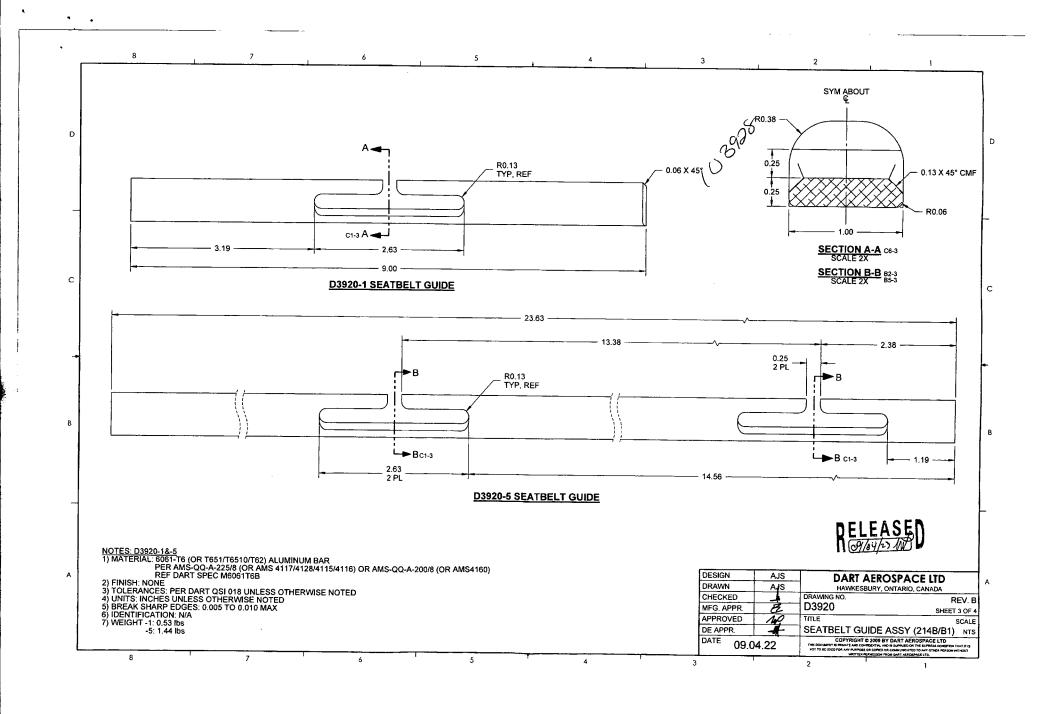
DQA:	.: Date:										NA DT				
			_			WORK ORDER NON-	-CC	ONFO	RMANCE / U				AEROSPACE		
QA Closed:			Date:							\	Nork Order น	pdate only			
Work Orde	er:					DISPOSITION				AGAINST D	DEPARTMENT	PROCESS			
	-				_	Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	io.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.	Quality		
	-					Use-as-is	1		noforming	Finishing	_	re/Packaging	Other		
NCR I	No.					Suspected Unapproved			Large Fab	Composite		Supplier			
	•					, , ,	1		0			- Anthus L			
Root					Descr	ription of work order update	1	nitial	Ac	tion	Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector		
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Handling/Pre															
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Supplier															
Training															
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							FA	ULT CAT	EGORY		-				
Landi	ng G	Gear				General									
		Bending				Bend		Folio/P	rogram		Outside Dir	nensions	Pressure/Forced		
		Centre No	t Concer	ntric		BOM/Route		Grain			Over/Unde	r tolerance	Set-up		
	Ш	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ect	Temperature/Cure		
	Ш	Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	on Incomplete/U	nqualified	Part Lost/N	lissing	Weld		
		Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Part Moved	. [Wrong Stock Pulled		
		Crushing				Countersink		Misalig	ned/off center	Γ	Positioned	Wrong			
	Heat Treat					Cut Too Short		Mislabe	eled	Γ	Power Loss	/Surge	Other		
	Inspection Strip in Tube					Drawing		Misread	ł	_					
	Marks/Chatter					Drill Holes		Off-set							
-	Turning Sequence					Finish	Out of Calibration								
. ,		Wave/Tw	ist in Tub	e		Fit/Function		Out of Sequence							



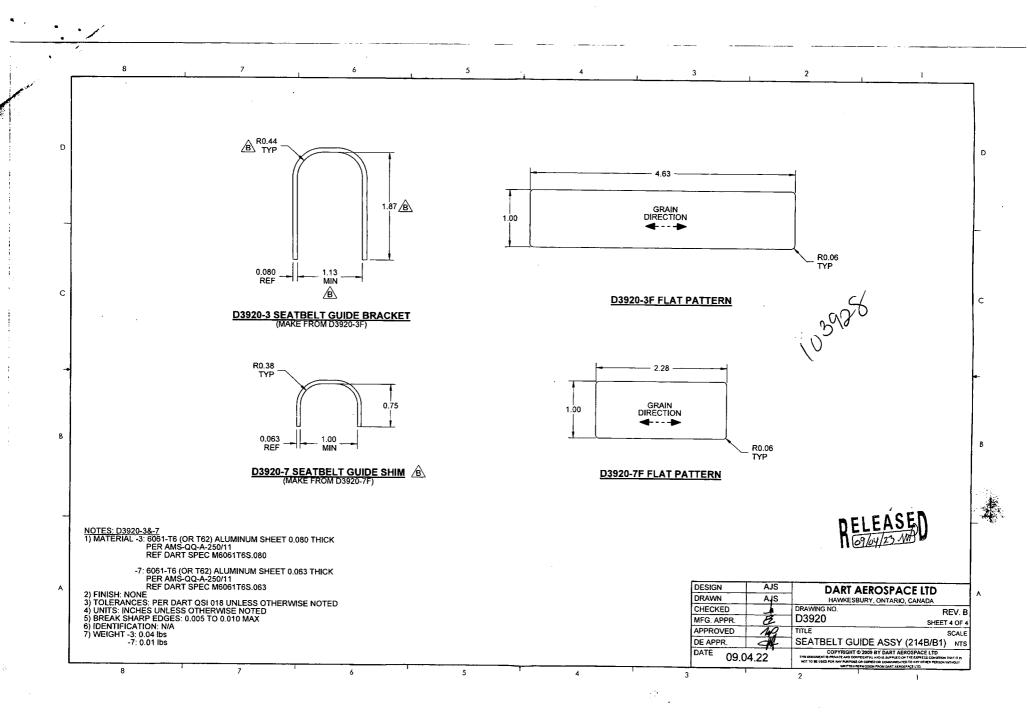
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QA Closed:			Date:								Work	Order up	date only]
Work Orde	er:					DISPOSITION			_	AGAINST [DEPA	RTMENT	PROCESS		
	-	·				Rework			Skid-tube	Crosstube			Water Jet	Г	Engineering
Part N	۱o					Scrap			Machining	Small Fab	7	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	۱o. <u>-</u>					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Descr	ription of work order update	ı	nitial	Ac	tion		Sign &	··-		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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Landi	ng G	iear				General	_	-		_				_	_
	\vdash	Bending				Bend		Folio/F	Program		o	utside Dim	ensions	L	Pressure/Forced
	Щ	Centre No	ot Concer	ntric		BOM/Route		Grain			oʻ	ver/Under	tolerance	L	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are	L	Pā	art Incorrec	:t	L	Temperature/Cure
		Crimp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified	Pa	art Lost/Mi	ssing	L	Weld
	\vdash	Cuffs			<u> </u>	Contamination		4	tions Incomplete/	Unclear	Pa	art Moved		L	Wrong Stock Pulled
	Crushing					Countersink		1	gned/off center		Po	ositioned V	/rong		
	Heat Treat					Cut Too Short		Mislabe	eled		Pc	ower Loss/	Surge		Other
	Inspection Strip in Tube					Drawing	Misread								
	Marks/Chatter					Drill Holes		Off-set	•					1	
	Turning Sequence					Finish		Out of	Calibration					!	
		Wave/Tw	ist in Tub	oe		Fit/Function		Out of Sequence							

5 QTY -041 PART NUMBER DESCRIPTION No. D3920-041 SEATBELT GUIDE ASSEMBLY 9 D3920-1 SEAT BELT GUIDE 10 D3920-3 SEAT BELT GUIDE BRACKET D3920-7 11 SEAT BELT GUIDE SHIM D3920-1 SEAT BELT GUIDE С SEATBELT GUIDE BRACKET (ASSEMBLE AT CHAMFERED END) -D3920-7 SEATBELT GUIDE SHIM (ASSEMBLE AT CHAMFERED END) 1.13 MIN **D3920-041 SEATBELT GUIDE ASSEMBLY** NOTES: D3920-041 1) MATERIAL: 1) MATERIAL:
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER DESIGN AJS DART AEROSPACE LTD DRAWN AJS HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B D3920 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE 7) WEIGHT: 0.58 lbs 8) WELDING: PER DART QSI 004 SEATBELT GUIDE ASSY (214B/B1) NTS DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD
THE DECLARACT IS PROVIDE AND CONTREST THE ABOUNDATION OF THE APPRAISE OSCUMENT
NOT TO BE LEED FOR ANY PLANGES OF CONTRES PERSONNELLED TO ANY CHIEF PRADE
MINISTER PERMISSION FROM DAY FACESPACE LTD. DATE 09.04.22

DQA:			Date:											**	A DT
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	IPDATE					AEROSPACE
QA Closed:			Date:								Wo	ork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST	DEI	PARTMENT	/PROCESS		
	-					Rework			Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	۱o. ِ					Scrap		1	Machining	Small Fab		Pro	d. Eng. Coor.	ヿ	Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR N	۱٥					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		nitial	Ac	tion		Sign &		\exists	
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		Bending				Bend			rogram	ļ		Outside Dim	-		Pressure/Forced
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	-	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa			$\overline{}$	Part Incorred			Temperature/Cure
	${f -}$	Crimp/Kin	ık/Ripple	/Wave	<u> </u>	Burrs		l '	on Incomplete/U	· · · · · · · · · · · · · · · · · · ·	_	Part Lost/Mi	- F		Weld
	\vdash	Cuffs			<u> </u>	Contamination	-	İ	ions Incomplete/		-	Part Moved			Wrong Stock Pulled
	Crushing					Countersink	-	_	ned/off center		_	Positioned V			
	Heat Treat					Cut Too Short	\vdash	Mislabe		l		Power Loss/	Surge [Other
:	Inspection Strip in Tube					Drawing	$ldsymbol{ldsymbol{ldsymbol{\sqcup}}}$	Misread	1						
•	Marks/Chatter					Drill Holes	Ш	Off-set							
	Turning Sequence					Finish	Out of Calibration								
		Wave/Tw	ist in Tub	e		Fit/Function	Out of Sequence								



DQA:			Date:											*	DA DT
			WORK ORDER NON-CONFORMANCE / UPDATE								AEROSPACE				
QA Closed:			Date:								W	ork Order up	date only		
Work Order:						DISPOSITION	AGAINS			AGAINST	ST DEPARTMENT/PROCESS				
	_					Rework			Skid-tube	Crosstube			Water Jet	\neg	Engineering
Part N	No.					Scrap		1 		Small Fab		Prod. Eng. Coor.			Quality
	_					Use-as-is				Finishing		Rec/Store/Packaging			Other
NCR I	No			<u>-</u>		Suspected Unapproved	⊣		Composite	H		_			
Root					Desci	ription of work order update	Į	nitial	A	ction		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription		Date	Verification	<u>1</u>	QC Inspector
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Equip/Tooling	Ц														
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Landi	ng G	ear	-			General		OLI CA	IEGORI					—	
		Bending				Bend		Folio/P	rogram			Outside Dim	ensions [Pressure/Forced
	-	Centre No	ot Concer	ntric		BOM/Route	Н	Grain		:	\vdash	Over/Under	+		Set-up
	\vdash	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	ıre		\vdash	Part Incorred	- F		Temperature/Cure
	П	Crimp/Kir	nk/Ripple	/Wave		Burrs	\vdash	ł	ion Incomplete/l	Unqualified	┢	Part Lost/Mi	}		Weld
		Cuffs				Contamination			ions Incomplete	•		Part Moved	Ĭ		Wrong Stock Pulled
	Crushing			Countersink	-	•	ned/off center			Positioned V	ر Vrong		, -		
	$\boldsymbol{-}$	Heat Trea	it			Cut Too Short	_	Mislabe				Power Loss/	· ·		Other
		Inspection	n Strip in	Tube		Drawing		Misread	d			•	•		
		Marks/Ch	atter			Drill Holes		Off-set							
,		Turning S	equence			Finish		Out of 0	Calibration						
Wave/Twist in Tube				Fit/Function		Out of Sequence					<u> </u>				



DQA:			Date:									•	NA DT			
			WORK ORDER NON-CONFORMANCE / UPDATE													
QA Closed: Date:									Work Order update only							
Work Order:				DISPOSITION AGAINST DEP			DEPARTMENT	PARTMENT/PROCESS								
	_					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering			
Part N	No.					Scrap			Machining	Small Fab	Pro	nd. Eng. Coor.	Quality			
	_					Use-as-is		Thermoforming Finishing			re/Packaging	Other				
NCR N	۷o.					Suspected Unapproved	1		Large Fab	Composite		Supplier				
													-			
Root					Desci	ription of work order update	I	nitial	Ac	tion	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector			
Design																
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	Ш°	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Unde	tolerance	Set-up			
	∐'	Cracks				Broken/Damage/Defect		Hardwa	re ·		Part Incorre	ct	Temperature/Cure			
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/U	Inqualified	Part Lost/M	issing	Weld			
		Cuffs				Contamination		Instruct	ions Incomplete/	'Unclear [Part Moved		Wrong Stock Pulled			
	Crushing			Countersink		Misaligned/off center		Positioned Wrong		 :						
	U	Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss	/Surge	Other			
		nspection	n Strip in	Tube		Drawing		Misread	t	•						
		Marks/Ch	atter			Drill Holes		Off-set								
•		Turning S	equence			Finish		Out of (Calibration							
Wave/Twist in Tube				Fit/Function		Out of 9	Sequence									

DART AEROSPACE LTD	Work Order:	103928
Description: Seat belt Guide Shim	Part Number:	03920-7
Inspection Dwg: \$\int 3900 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1,00"	11-0.030° 11-0.030° 11-0.010°	D. 998°	_		U	JEMOI
<u> </u>	11-0.030	2.274"	-		U	
0.063"	11-0.010"	0,060			U	
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	<u> </u>					
		 				
			6	-		

			DAS		
Measured by:	Jm	Audited by:	09	Preliminary Approval:	
Date:	13-07-08	Date:	13-07-09	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15